

Work Order ID 67912

Monday, April 04, 2011 2:42:47 PM



Page 1

Item ID: D407-558-045

Accept



Setup Start



Revision ID:

Item Name: Single Cargo Mirror Assembly

Stop



Start Date: 4/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 4/4/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D407-558-045 and DSI 9436 CHG002

Sulcis/Br

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D206-558

7m.k 11/04/08

(IX)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Sulcis/Br

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Setup Start



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Stop



Item Name: Single Cargo Mirror Assembly

Start Date: 4/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

125

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/4/12

130

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sulco 130

76

140

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D407-558-045 and DSI 9436

Location:

PPP Rev: B

11/4/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 67912

Monday, April 04, 2011 2:42:47 PM



Page 3

Item ID: D407-558-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Single Cargo Mirror Assembly

Start Date: 4/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

N/C/C/D
ME

11-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 04, 2011 2:43:50 PM

Page 1

Work Order ID: 67912

Parent Item: D407-558-045

Parent Item Name: Single Cargo Mirror Assembly



Start Date: 4/4/2011

Required Date: 4/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-01-15 new issue DD verified by:ec IPP Rev:B
10.06.17 added grommet DD verf:EC IPP REV:C 11.01.19 AS
PER chg002 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS35489-67 GROMMET		Purchased	No				Each	18.0000	1				
AN960JD10 Washer	NAS1149D0363J	Purchased	No				Each	0.0000	4				
D2011-101 6" Mirror		Manufactured	No				Each	38.0000	1				
D2052 Mounting Bracket		Manufactured	No				Each	11.0000	2				

Location Loc Qty Loc Code

ST296 18
111193 18

M116583

Location Loc Qty Loc Code

ST221 38
65838 38

Location Loc Qty Loc Code

ST005 11
59809 11

67743

2X

~~11/04/06~~
11/4/06

~~4X m-k 11/04/06~~

m-k 11/04/06

~~1X~~
2
m-k 11/04/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, April 04, 2011 2:43:51 PM

Page 2

Work Order ID: 67912

Parent Item: D407-558-045

Parent Item Name: Single Cargo Mirror Assembly

Start Date: 4/4/2011

Required Date: 4/6/2011

Start Qty: 1.00

Required Qty: 1.00

D2054

Manufactured No

110 Each

22.0000

2

2



Bushing

Location

Loc Qty

Loc Code

GA

22

61834 ✓

22

Manufactured No

110 Each

9.0000

1

D2055



Clamp

Location

Loc Qty

Loc Code

GA

9

58393 ✓

9

Manufactured No

110 Each

12.0000

1

D2056



Bell Crank

Location

Loc Qty

Loc Code

GA

12

45542 ✓

2

66183 ✓

10

Manufactured No

110 Each

14.0000

1

D2057



Plug

Location

Loc Qty

Loc Code

ST005

14

60880

14

Manufactured No

110 Each

9.0000

1

D2065



Arm

Location

Loc Qty

Loc Code

ST229

9

61381 ✓

9

m-k 11/04/06

2x
m-k 11/04/06

1x
m-k 11/04/06

1x
m-k 11/04/06

1x
m-k 11/04/06

1x

Monday, April 04, 2011 2:43:51 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Monday, April 04, 2011 2:43:51 PM

Work Order ID: 67912

Parent Item: D407-558-045

Parent Item Name: Single Cargo Mirror Assembly

Start Date: 4/4/2011

Required Date: 4/6/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No

110 Each

2,074.000

2

2



Nut



m-l 11/04/06

Location

Loc Qty

Loc Code

ST300

2074

116391 ✓

474

116540

800

116549

800

2x

MS27039-1-18 Purchased No

110 Each

114.0000

2

2



Screw



m-l 11/04/06

Location

Loc Qty

Loc Code

ST292

114

113845 ✓

14

115589

100

2x

AN3-4A Purchased No

125 Each

0.0000

4

4



Bolt



M119374 sl

AN526-1032R9 Purchased No

125 Each

52.0000

4

4



Screw



114112 sl

Location

Loc Qty

Loc Code

ST328

52

116900

52

125 Each

0.0000

6

6

AN960ID10L NAS1149D0332J Purchased No



Washer



M117010 sl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 04, 2011 2:43:52 PM

Work Order ID: 67912

Parent Item: D407-558-045

Parent Item Name: Single Cargo Mirror Assembly

Start Date: 4/4/2011

Required Date: 4/6/2011

Start Qty: 1.00

Required Qty: 1.00

D2053
Mounting Bracket

Manufactured No

125 Each

13.0000



11/4/12

Location

Loc Qty

Loc Code

ST005

13

65837

13

D2067
Connector

Manufactured No

125 Each

0.0000



B67403-4151308

D2071-3
Cable

Manufactured No

125 Each

10.0000



11/4/12

Location

Loc Qty

Loc Code

ST222

10

64745

10

D3778-1
Bracket

Manufactured No

125 Each

5.0000



11/4/12

Location

Loc Qty

Loc Code

ST277

5

65835

5

MS21042L3
Nut

Purchased No

125 Each

2,074.000



11/4/12

Location

Loc Qty

Loc Code

ST300

2074

116391

474

116540

800

116549

800

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 5

Monday, April 04, 2011 2:43:52 PM

Work Order ID: 67912

Parent Item: D407-558-045

Parent Item Name: Single Cargo Mirror Assembly



Start Date: 4/4/2011

Required Date: 4/6/2011

Start Qty: 1.00

Required Qty: 1.00

MS21919-DG5

Purchased

No

125

Each

22.0000

2

2



Clamp



11/4/12 SF

Location

Loc Qty

Loc Code

ST306

22

116805

22

2

Monday, April 04, 2011 2:43:52 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

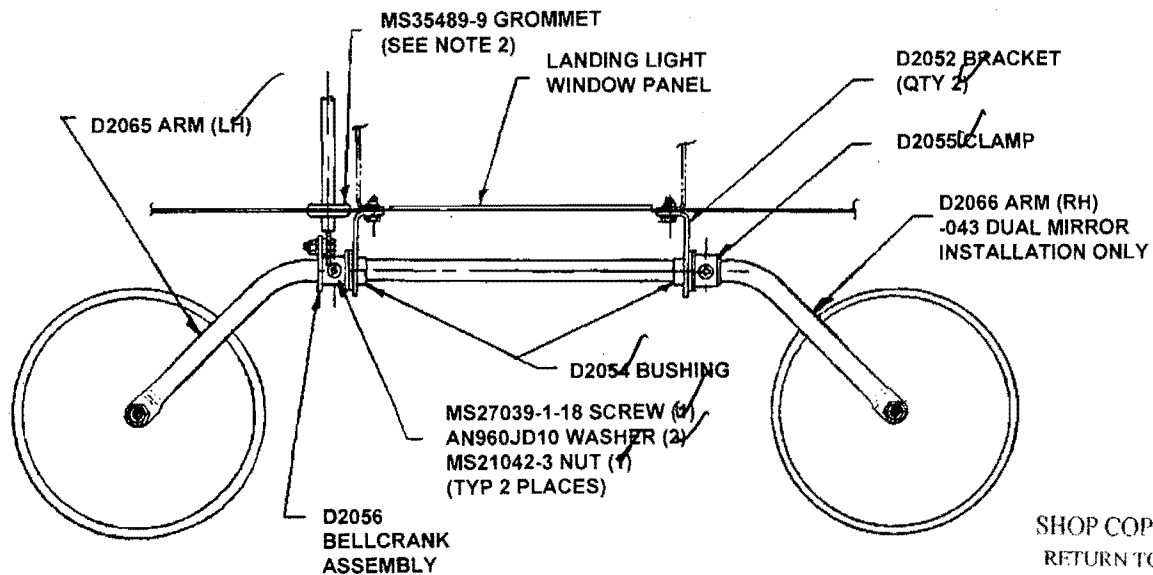


Figure 25.2 – View A: Looking Aft.
(D206-558-043 Mirror Shown)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61912

pl 1109-4

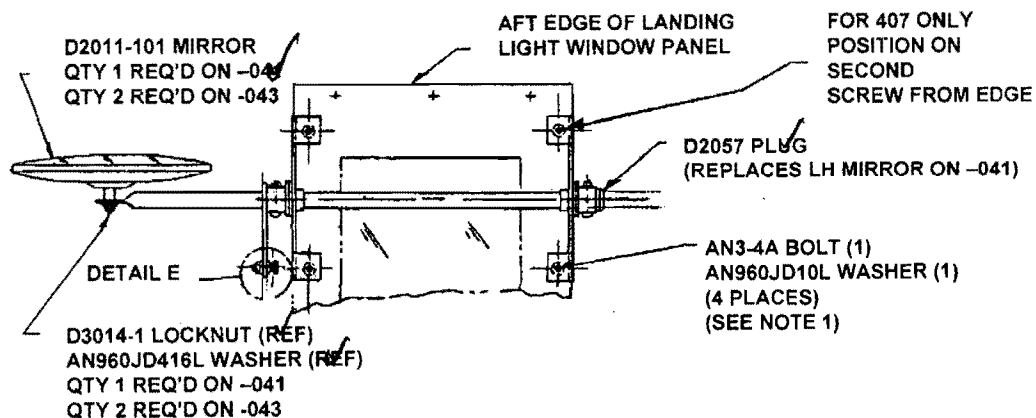


Figure 25.3 – View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

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25-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

FROM THIS POINT FORWARD, CUSTOMERS SHOULD ORDER D407-558-045/-047 IN LIEU OF D206-558-041/-043 WHEN PROCURING SINGLE/DUAL MIRRORS FOR BHT 407 MODELS. AMEND SECTIONS 4.0 AND 5.0 OF INSTALLATION INSTRUCTIONS D206-558 REV. C OR EARLIER AND 25.3 AND 25.4 OF ICA-D206-558 REV. 0 AS FOLLOWS:

4.0 WEIGHT AND BALANCE (D206-558 REV. C OR EARLIER)

25.3 WEIGHT AND BALANCE (ICA-D206-558 REV. 0)

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 206A/B/L/L1/L3/L4	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D206-558-043	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 206A/B/L/L1/L3/L4	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg
D407-558-045	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 407	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D407-558-047	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 407	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg

5.0 PARTS LIST (D206-558 REV. C OR EARLIER)

25.4 PARTS LIST (ICA-D206-558 REV. 0)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X			D206-558-043	DUAL CARGO MIRROR ASSEMBLY
		X		D407-558-045	SINGLE CARGO MIRROR ASSEMBLY
			X	D407-558-047	DUAL CARGO MIRROR ASSEMBLY
1	2	1	2	D2011-101	MIRROR ASSEMBLY
2	2	2	2	D2052	BRACKET
1	1	1	1	D2053	BRACKET
2	2	2	2	D2054	BUSHING
1	1	1	1	D2055	CLAMP
1	1	1	1	D2056	BELLCRANK ASSEMBLY
1		1	1	D2057	PLUG
1		1	1	D2065	ARM
	1		1	D2066	ARM
1	1	1	1	D2067	CONNECTOR
1	1			D2071	CABLE ASSEMBLY
		1	1	D2071-3	CABLE ASSEMBLY
1	2	1	2	D3014-1	* LOCKNUT
1	1	1	1	D3778-1	BRACKET
4	4	4	4	AN3-4A	BOLT
4	4	4	4	AN526-1032R9	SCREW
1	2	1	2	AN960JD416L	* WASHER
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD10L	WASHER
3	3	3	3	MS21042-3	NUT (or MS21042L3) -2
2	2	2	2	MS21919DG5	CLAMP
2	2	2	2	MS27039-1-18	SCREW
1	1			MS35489-9	GROMMET
		1	1	MS35489-67	GROMMET







* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHARD (DE # 02)

DATE: 08.12.04
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
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